

**INDIANA DEPARTMENT OF TRANSPORTATION
OFFICE OF MATERIALS MANAGEMENT**

**CERTIFIED PRECAST CONCRETE PRODUCER PROGRAM
ITM 813-08P**

1.0 SCOPE.

- 1.1** This procedure covers the requirements for a precast concrete plant to become a Department Certified Precast Concrete Producer for precast concrete products.
- 1.2** All precast concrete products are required to be in accordance with the Department Standard Specifications.
- 1.3** The values stated in either English or acceptable SI metric units are to be regarded separately as standard, as appropriate for a specification with which this ITM is used. Within the text, SI metric units are shown in parenthesis. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other, without combining values in any way.
- 1.4** This procedure may involve hazardous materials, operations, and equipment and may not address all of the safety problems associated with the use of the test method. The user of this ITM is responsible for establishing the appropriate safety and health practices and determining the applicability of regulatory limitations prior to use.

2.0 REFERENCES. Copies of the most recent following AASHTO test methods shall be retained on file.

2.1 AASHTO Standards.

- M 86M Concrete Sewer, Storm Drain, and Culvert Pipe
- M 170 Reinforced Concrete Culvert, Storm Drain, and Sewer Pipe
- M 170M Reinforced Concrete Culvert, Storm Drain, and Sewer Pipe
(Metric)
- M 199M Precast reinforced Concrete Manhole Sections
- M 207 Reinforced Concrete Elliptical Culvert, Storm Drain, and Sewer Pipe
- M 207M Reinforced Concrete Elliptical Culvert, Storm Drain, and Sewer Pipe
(Metric)
- M 259 Precast Reinforced Concrete box Sections for Culverts, storm Drains,
and Sewers
- M 259M Precast Reinforced Concrete box Sections for Culverts, storm Drains,
and Sewers (Metric)

M 273	Precast Reinforced Concrete Box Sections for Culverts, Storm Drains, and Sewers with Less Than Two Feet of Cover Subjected to Highway Loadings
M 273M	Precast Reinforced Concrete Box Sections for Culverts, Storm Drains, and Sewers with Less Than Two Feet of Cover Subjected to Highway Loadings (Metric)
T 22	Compressive Strength of Cylindrical Concrete Specimens
T 23	Making and Curing Concrete Test Specimens in the Field
T 24	Obtaining and Testing Drilled Cores and Sawed Beams of Concrete
T 119	Slump of Hydraulic Cement Concrete
T 121	Mass per Cubic Meter (Cubic Foot), Yield, and Air Content (Gravimetric) of Concrete
T 141	Sampling Freshly Mix Concrete
T 152	Air Content of Freshly Mixed Concrete by the Pressure Method
T 196	Air Content of Freshly Mixed Concrete by the Volumetric Method
T 280	Concrete Pipe, Manhole Sections, or Tile

2.2 ASTM Standards.

C 39	Compressive Strength of Cylindrical Concrete Specimens
C 31	Making and Curing Concrete Test Specimens in the Field
C 42	Obtaining and Testing Drilled Cores and Sawed Beams of Concrete
C 143	Slump of Hydraulic Cement Concrete
C 138	Mass per Cubic Meter (Cubic Foot), Yield, and Air Content (Gravimetric) of Concrete
C 172	Sampling Freshly Mix Concrete
C 231	Air Content of Freshly Mixed Concrete by the Pressure Method
C 173	Air Content of Freshly Mixed Concrete by the Volumetric Method
C 497	Concrete Pipe, Manhole Sections, or Tile

3.0 TERMINOLOGY. Definitions for terms and abbreviations shall be in accordance with the Department's Standard Specifications Section 101 and the following:

- 3.1 ACPA. American Concrete Pipe Association.
- 3.2 Addenda. Any addition or deletion to the QCP.
- 3.3 Approved Lists. A compilation of lists identified in the Department Standard Specifications that require products, sources, equipment or other specified items to be approved and on a list prior to consideration for use on a Department contract.

- 3.4** **Audit.** An inspection conducted by an independent party selected by the ACPA or NPCA that verifies compliance with the Department Certified Precast Producer Program.
- 3.5** **Certified Precast Concrete Plant.** A precast concrete plant certified by the ACPA or the NPCA, and in accordance with the Program.
- 3.6** **NPCA.** National Precast Concrete Association.
- 3.7** **Program.** ITM 813
- 3.8** **QCP.** The Quality Control Plan for the plant that is site-specific and specifies the production, policies and procedures used by the plant.
- 4.0** **SIGNIFICANCE AND USE.** The Certified Precast Concrete Producer Program is a program whereby the Producer takes responsibility for the production of quality precast concrete products in accordance with contract requirements, and the Department monitors the Producer's quality control procedures.
- 5.0** **PRODUCER PERSONNEL**
 - 5.1** **Management Representative.** The Management Representative shall be responsible for all aspects of production and quality control required by the Program at a Precast Concrete Plant and shall be the liaison with the Department.
 - 5.2** **Quality Control Technician.** The Quality Control Technician shall be an ACI Concrete Field Testing Technician, Grade I.
- 6.0** **MATERIALS.** Materials incorporated into the precast concrete products shall be in accordance with the following:
 - 6.1** **Admixtures.** Chemical admixtures shall be included in the Department List of Approved PCC Admixtures and Admixture Systems.
 - 6.2** **Aggregates.** Aggregates shall be in accordance with ITM 203.
 - 6.3** **Cement.** Cement shall be included in the Department List of Approved Cement Sources.
 - 6.4** **Manhole Steps.** Manhole steps shall be included in the Department List of Approved Manhole Steps.
 - 6.5** **Pozzolans.** Pozzolans shall be included in the Department List of Approved Pozzolans Sources.

6.6 Reinforcing Steel. Reinforcing steel shall be included in the Department List of Approved Certified Uncoated Reinforcing Bar Manufacturers.

6.7 Welded Steel Wire Fabric. Welded steel wire fabric shall be in accordance with 910.01 (b).

7.0 MATERIALS TESTING. The Producer shall test the precast products in accordance with the following test procedures:

Test	AASHTO Test Method	ASTM Test Method
Absorption	T 280	C 497
Air Content (Pressure Method)	T 152	C 231
Air Content (Volumetric Method)	T 196	C 173
Compressive Strength	T 22	C 39
Concrete Cores	T 24	C 42
Making and Curing Concrete Specimens	T 23	C 31
Sampling Concrete	T 141	C 172
Slump	T 119	C 143
Three-Edge Bearing	T 280	C 497
Unit Weight	T 121	C 138

8.0 PRODUCT MARKING. Precast concrete products shall be marked with the date of manufacturing, Department identification number, ACPA or NPCA certification identification marking, and the applicable Standard Specification required marking.

8.1 The ACPA product marking shall be the "QCast" emblem or the words "ACPA Certified Product".

8.2 The NPCA product marking shall be the words "NPCA Certified Product".

9.0 QUALITY CONTROL PLAN. Each Producer providing precast concrete products under the Program shall have a written QCP that shall be plant specific and be the basis of control. The QCP shall contain, but not be limited to, the methods of production and quality control policies and procedures used by the plant. The QCP shall be in accordance with ACPA or NPCA Plant Certification requirements and the Program.

10.0 CERTIFICATION.

10.1 Each plant requesting to become a Certified Precast Concrete Producer shall do so in writing to the Manager, Office of Materials Management. The request shall include a copy of the compliance certificate issued by the ACPA or NPCA, a copy of the most recent audit conducted in accordance with the ACPA and NPCA certification programs, a copy of the response to deficiencies of the audit, if applicable, a copy of the QCP, and the designated Management Representative for the plant.

- 10.2** Each plant meeting the requirements of the Program will be certified upon verification of the required documents of 10.1.
- 10.3** Each certified Precast Concrete Plant is required to submit to the Office of Materials Management a copy of the annual audit and the response to deficiencies of the audit, if applicable, to verify compliance with the ACPA and NPCA certification programs.
- 10.4** In the event of a change in ownership of the Certified Precast Concrete Producer, the certification shall expire on the date of such change. The new ownership may avoid expiration by submitting a statement to the Office of Materials Management indicating recognition of the details of the Program and verification that the plant is in accordance with the ACPA and NPCA certification program requirements.

11.0 DEPARTMENT RESPONSIBILITIES.

- 11.1** The Department may conduct annual audits on a random basis of each Certified Precast Plant.
- 11.2** The Department will maintain the List of Approved Certified Precast Concrete Producers.
- 11.3** The removal of a plant from the Department's List of Approved Certified Precast Concrete Producers will be the responsibility of the Manager, Office of Materials Management. The Producer shall have the right to appeal the removal from the Department's List of Approved Certified Precast Concrete Producers to the Director, Construction Management Division.